

Date: Monday, 2/11/2008 2:12:02 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, INBOARD, LS, 206
 Job Number : 37332
 Estimate Number : 10820
 P.O. Number :
 This Issue : 2/11/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D26661
 Drawing Number : D2666 REV. D
 Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : D
 Material :
 Previous Run : 36185 Due Date : 2/28/2008 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : 2/11/08 0211
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house
 processEC
 Est Rev:D As per Rev D 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

2/11/08 Batch No: B3464/B

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

2-Fixturing Inspection last completed on 2/11/08 by DJP

3-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

8-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

9- Deburr

2/11/08

DJP

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

2/11/08

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2/11/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		<i>up 2632</i>						

Part No: D2666-1 PAR #: N/A Fault Category: Prod / Machine ^{PAB} NCR: Yes No DQA: D Date: 08/05/02
 QA: N/C Closed: D Date: 08/05/02

NCR: <u>37332</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/28	2.0	operator removed the case 649 instead of <u>70</u> RC: Human error.	<i>[Signature]</i> 08/04/28	Scrap and Destroy and Repl/see	08/04/28 DJP	<i>[Signature]</i> 08/05/02	<i>[Signature]</i> 08/04/28	<i>[Signature]</i> 08/04/28

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:12:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 37332

Part Number: D26661

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/04/29

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.H 08/0

(10X)

1337332

D26661

30/04/2008

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107550

HJ 08-04-30

S.164 14.19
#1 323.3 F
#2 --- F
#3 30NKS F
#4 --- F

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

J.S M.H

08/04/30

(10X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 426

J.S 08/05/01 (10X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/01 J.S

Job Completion



MF 08-05-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

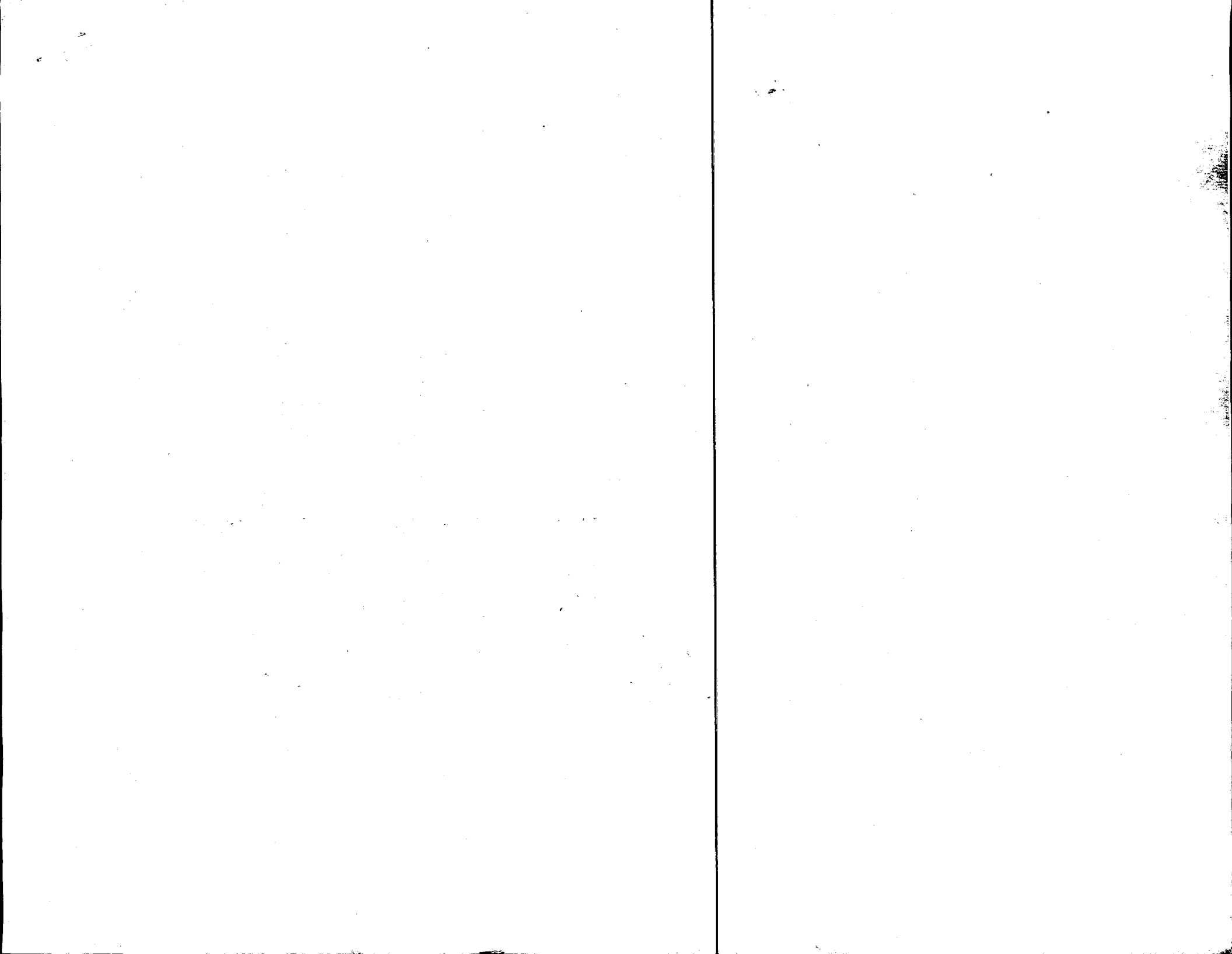
DART AEROSPACE LTD	Work Order: 37332
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.118	0.119	0.118	0.117		
B	0.100	0.140		0.121	0.119	0.1195	0.120		
C	2.470	2.510		2.490	2.500	2.490	2.500		
D	0.100	0.180		0.160	0.160	0.165	0.165		
E	0.210	0.230		0.220	0.219	0.219	0.219		
F	1.313	1.343		1.3245	1.3215	1.320	1.3215		
G	0.240	0.260		0.247	0.248	0.247	0.248		
H	0.615	0.685		0.650	0.650	0.650	0.650		
I	1.125	1.145		1.1355	1.1345	1.135	1.135		
J	0.990	1.010		0.996	0.996	0.996	1.001		
K	0.235	0.240			.236	.236	.236		
L	0.510	0.515			.510	.510	.510		
M	0.100	0.120		0.112	0.112	0.113	.113		
N	1.565	1.585		1.5765	1.5755	1.576	1.576		
O	5.990	6.010		6.002	6.002	6.002	6.002		
P	1.245	1.255		1.251	1.248	1.249	1.250		
Q	2.495	2.505		2.499	2.501	2.498	2.500		
R	0.490	0.510		0.497	0.4975	0.499	.501		
S	0.313	0.318		0.314	0.314	0.314	.313		
T	2.495	2.505		2.499	2.500	2.500	2.499		
U	1.357	1.367		1.362	1.361	1.362	1.361		
V	0.315	0.322		0.322	0.322	0.322	0.322		
W	0.540	0.560		0.552	0.552	0.552	0.552		
X	1.674	1.684		1.677	1.676	1.677	1.679		
Y	0.257	0.262		0.259	0.259	0.259	0.259		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DTP	Audited by: J.L
Date: 08/04/27	Date: 08/04/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	



DART AEROSPACE LTD	Work Order: 37332
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	4	5	6	7		
A	0.100	0.140		0.119	.120	.120	.120		
B	0.100	0.140		0.121	0.121	0.120	.120		
C	2.470	2.510		2.500	2.495	2.495	2.499		
D	0.100	0.180		0.165	.165	.160	.160		
E	0.210	0.230		.220	0.220	0.220	.220		
F	1.313	1.343		1.321	1.323	1.322	1.321		
G	0.240	0.260		0.247	.249	.248	.250		
H	0.615	0.685		0.650	.650	0.650	.650		
I	1.125	1.145		1.135	1.135	1.135	1.135		
J	0.990	1.010		1.002	1.000	1.000	1.001		
K	0.235	0.240		.235	.235	.235	.235		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.112	.110	.112	.112		
N	1.565	1.585		1.576	1.576	1.576	1.575		
O	5.990	6.010		6.002	6.002	6.003	6.002		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.501	.502	.502	.502		
S	0.313	0.318		.313	.313	.313	.313		
T	2.495	2.505		2.500	2.498	2.499	2.500		
U	1.357	1.367		1.362	1.360	1.361	1.361		
V	0.315	0.322		0.322	0.322	0.322	0.322		
W	0.540	0.560		0.553	.550	.553	.551		
X	1.674	1.684		1.679	1.678	1.678	1.678		
Y	0.257	0.262		0.259	0.259	0.259	.259		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DJT
Date: 08/04/28

Audited by: J.L
Date: 08/04/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 37332
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	8	9	10	11		
A	0.100	0.140		.117	.119	.119			
B	0.100	0.140		.118	.118	.118			
C	2.470	2.510		2.500	2.500	2.500			
D	0.100	0.180		.165	.170	.170			
E	0.210	0.230		.220	.220	.220			
F	1.313	1.343		1.321	1.321	1.321			
G	0.240	0.260		.250	.250	.250			
H	0.615	0.685		.665	.665	.665			
I	1.125	1.145		1.135	1.135	1.135			
J	0.990	1.010		1.000	1.000	1.000			
K	0.235	0.240		.235	.235	.235			
L	0.510	0.515		.510	.510	.510			
M	0.100	0.120		.112	.112	.112			
N	1.565	1.585		1.575	1.575	1.575			
O	5.990	6.010		6.000	6.000	6.000			
P	1.245	1.255		1.250	1.250	1.250			
Q	2.495	2.505		2.500	2.500	2.500			
R	0.490	0.510		.500	.500	.500			
S	0.313	0.318		.313	.313	.313			
T	2.495	2.505		2.500	2.500	2.500			
U	1.357	1.367		1.362	1.362	1.362			
V	0.315	0.322		.315	.315	.315			
W	0.540	0.560		.550	.550	.550			
X	1.674	1.684		1.682	1.682	1.682			
Y	0.257	0.262		.258	.258	.258			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: 87
Date: 08/04/29

Audited by: J.L
Date: 08/04/29

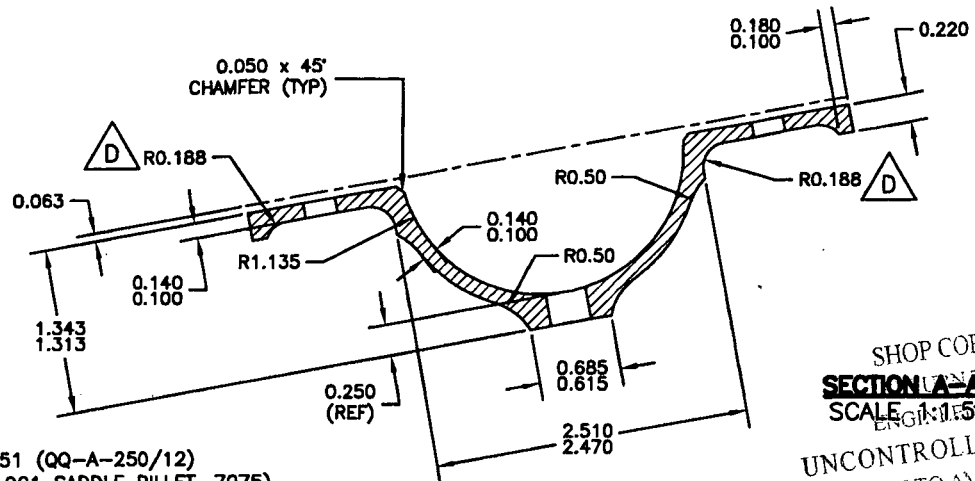
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

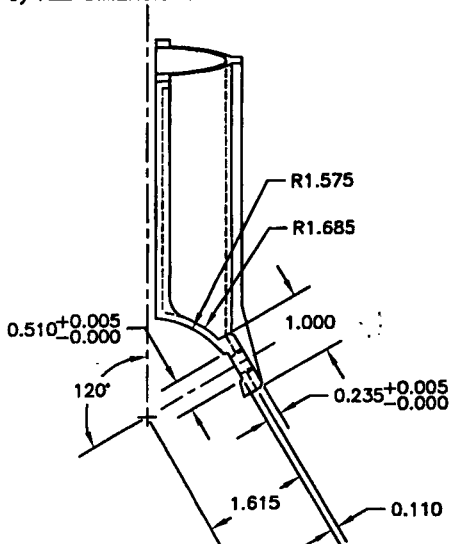
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07.02.12 [Signature]

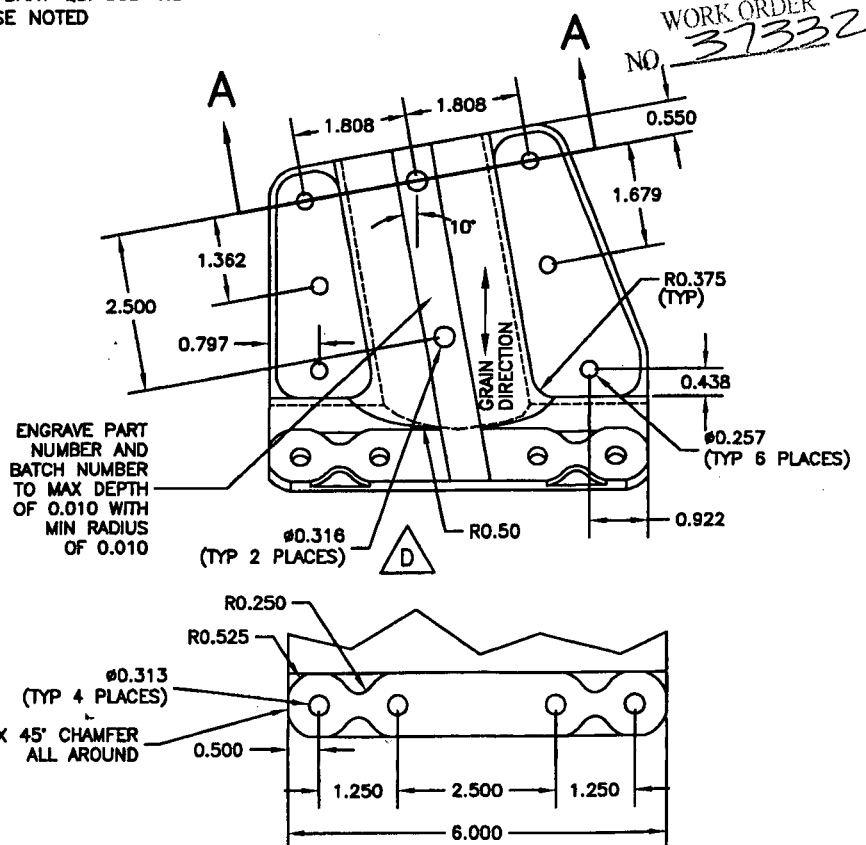


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2666-1 SADDLE FWD INSIDE HIGH



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NO. 37332

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